

Date: Monday, 02/03/2009 9:10:14 AM
 User: Melanie Fauteux

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	END FITTING ASS'Y
Job Number :	46158		
Estimate Number :	13475		
P.O. Number :		Part Number :	D3763045
This Issue :	02/03/2009	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D3763 REVB
First Issue :	/ /	Project Number :	N/A
Previous Run :	42957	Drawing Revision :	B
	Type :	Material :	
	SMALL /MED FAB	Due Date :	09/03/2009
Written By :		Qty:	10
Checked & Approved By :	<u>mf 09-03-02</u>	Um:	Each
Comment :	Est Rev:A 08-07-18 new issue DD verified by:ec Est Rev:B 08-08-11 add chemical coat and qc3 DD verified by:EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
 Pick Packing Kit

2.0	D37631	End Fitting
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)
 End Fitting
 batch: B45891 = 10x

SP 09.03.19

3.0	D37637	Tube
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)
 Tube
 batch: B40991 = 2x B40731 = 8x

SP 09.03.19

4.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1
 1-make a 0.063" chamfer on D3763-1 fitting before ass'y
 2-assemble and tack weld as per dwg D3763 using locating pin DT9039
 remove pin before welding*

3-weld as per dwg D3763, QSI004

Alum. rod Batch: M164855

SP 09.03.19 (10x)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: END FITTING ASS'Y

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Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

09/03/20

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

09-3-20

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

04-03-23

(10)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL 09/03/23

(10)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with Dart part # using a fine point permanent marker and Stock

Location: _____

57251

09/3/23

(10)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/03/24

Job Completion



MF 09-03-23

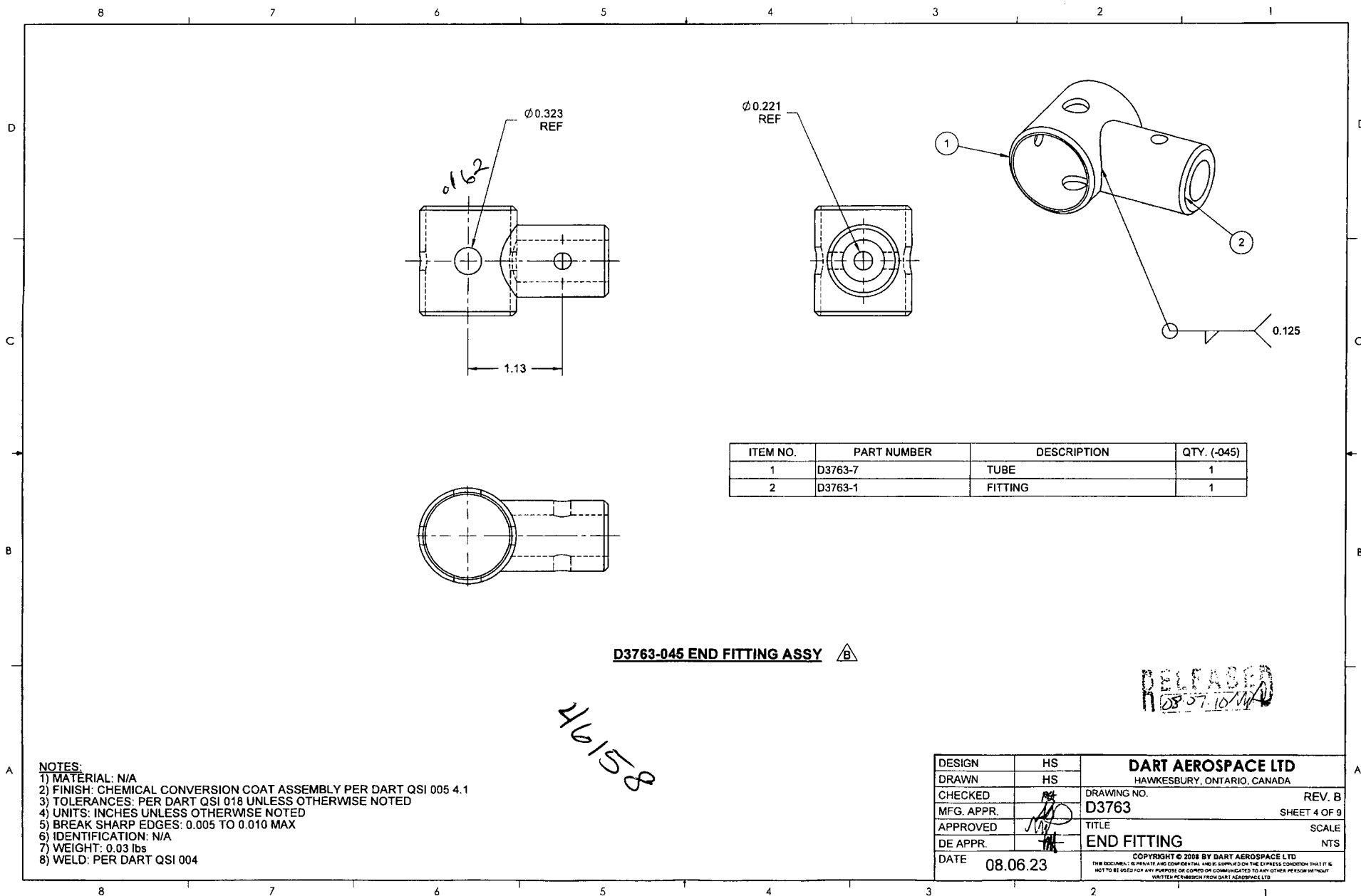
W/O:		WORK ORDER CHANGES					
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W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries